

ASAP Split

Date
UserMonday, 10/22/2007 3:41:39 PM
Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BAR

Job Number : 35281-1

Estimate Number : 10390

P.O. Number : N/A

This Issue : 10/22/2007 S.O. No. : N/A

Prsht Rev. : NC

First Issue : N/A Type : MACHINED PARTS

Previous Run : 30655

Part Number : D3197041

Drawing Number : D3197 REV B

Project Number : N/A

Drawing Revision : B

Material : N/A

Due Date : 11/5/2007

Qty: 4 Um: Each

Written By :

Checked & Approved By :

Comment :

Est Rev: A New Issue 05-11-08 JLM

Est Rev: B As per Rev B 06-03-10 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M7075T73R1000

7075-T73 Round Bar 1" OD



Comment: Qty.: 2.5410 f(s)/Unit Total : 30.4920 f(s)
 Material: 7075-T73 (QQ-A-200/11) or (QQ-A-225/9) 1" OD
 (M7075T73R1.000)
 Identify for D3197-1
 Batch: 7106027-121

SA 07.10.27(4)

2.0

BAND SAW

BAND SAW



Comment: BAND SAW
 Cut blanks: 29.125" long

3.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Face ends to length per dwg D3197
 2-Machine D3197-1 as per Folio FA340 and Dwg D3197
 3-Deburr

SA 07.10.30

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 07.10.30

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Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LATHE CONV

CONVENTIONAL LATHE



Comment: CONVENTIONAL LATHE
Chamfer as per Dwg D3197

Handwritten: 07-10-30 (4)

6.0

QCS

SECOND CHECK



Comment: SECOND CHECK

Handwritten: J.F. 07/10/30 (4)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

Handwritten: F.L. 07/11/01 (4)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Handwritten: M 105642

Handwritten: BR 07-11-02

9.0

QCS

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: M-P 07/11/02 (4X)

10.0

D26905

Lanyard ass'y



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2690-5 Lanyard *Handwritten:* B25836 (x7)
B30611 (x1)

Handwritten: 07/11/02 AS

11.0

D32421

Tag



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3242-1 TAG *Handwritten:* B30665

Handwritten: 07/11/02 AS

Process Sheet

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Drawing Name: BAR

Job Number: 35281

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 72.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 AN960JD10

Washer M104625

07/11/02 AS

13.0

D34893200

PIP PIN



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3489-3-200

Pip Pin B226707

07/11/02 / AS

14.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS21042L3

Nut (or -3) M104625

07/11/02 AS

15.0

MS27039124

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-24 Screw

B100274

07/11/02 AS

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3197-041 as per Dwg D3197

mf 07-11-02 @

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/14/05 (x4)

Process Sheet

Customer: OU-DAR001 Dart Helicopters Services

Drawing Name: BAR

Job Number: 35281

Part Number: D3197041

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 247

(x4)

07/11/05

AS

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(4)

07/11/05

Job Completion

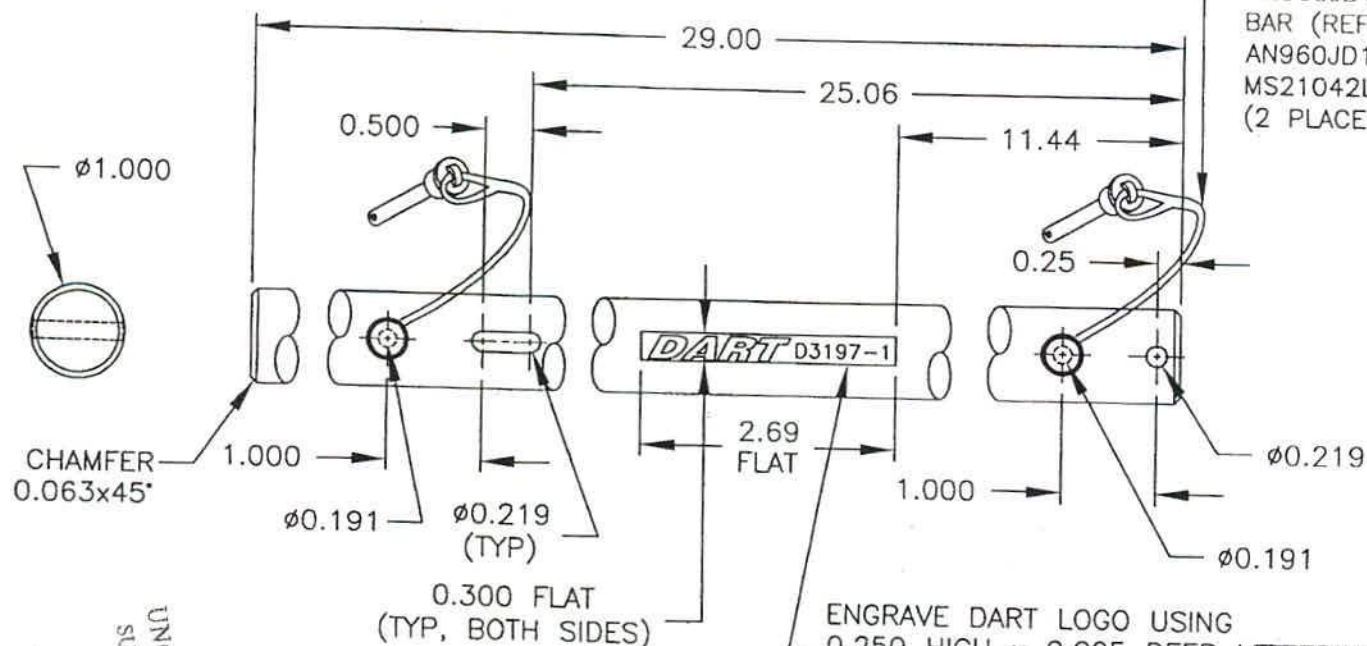


C207/11/05

DART

RELEASED

D3489-3-200 PIP PIN (1)
D3242-1 TAG (1)
MS27039-1-24 BOLT (1)
AN960JD10 WASHER (1)
D2690-5 LANYARD (1)
AN960JD10 WASHER (1)
BAR (REF)
AN960JD10 WASHER (1)
MS21042L3 NUT (1)
(2 PLACES)



D3197-041 BAR ASSEMBLY

ENGRAVE DART LOGO USING
0.250 HIGH x 0.005 DEEP LETTERING
AND P/N USING 0.150 HIGH x 0.005
DEEP LETTERING ON BOTH SIDES

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D.
(REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER
END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	D3197	SHEET
A	03.07.01	BAR	NEW ISSUE	
B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG		

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 35281

